| 4 | |
|------------------------|------------|
| Date: User: | Mor Kim |
| Customer Job Number | |

nday, 2/27/2006 4:18:23 PM Johnston **Process Sheet** : SADDLE, INBOARD, RS, 206 **Drawing Name** : CU-DAR001 Dart Helicopters Services : 25981 : 10821 **Estimate Number** : D26662 : NIA **Part Number** P.O. Number S.O. No. : NA D2666 REV. B **Drawing Number** : 2/27/2006 This Issue : N/A Project Number : NC Prsht Rev. : MA : MACHINED PARTS **Drawing Revision** Type First Issue : NIA : 24850 Material **Previous Run** : 3/25/2006 Qty: Each, **Due Date** Written By Checked & Approved By Removed P/O for Powder Coat - in house Comment processEC **Additional Product** Job Number: Description: Machine Or Operation: Sea. #: 7075-T7351 2X6X6.25 D6101001 1.0 1.0000 Each(s)/Unit Total: 12.0000 Each(s) Comment: Qty.: 7075-T7351 2X6X6.25 Issue material from stock: Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length 2.0 HAAS1 Comment: HAAS CNC VERTICAL MACHINING #1 Program batch number. 1-Inspect part number and batch number are programmed correctly. 2-Fixturing W/O No. ___**\O_J/A** 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet 7- Deburr CONVENTIONAL MILLING MACHINE MILLING CONV 3.0 Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet INSPECT PARTS AS THEY COME OFF MACHINE 4.0 QC2

Page 1

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Form: rprocess

Dart Aerospace Ltd

| W/O: | | | WO | RK ORDER CHAN | NGES | | | · · · · · · · · · · · · · · · · · · · |
|---------|------|-------------------|----------------------|-----------------------------|-------------------|--------------|-------------------------------|---------------------------------------|
| DATE | STEP | PRO | PROCEDURE CHANGE | | | Date Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | | |
| | | | | | | | | |
| Part No | : | PAR #: | Fault Categ | ory: | NCR: Yes | No DQA: | Date: _ | |
| | • . | | · . | | QA: N/ | C Closed: | Date: _ | |
| NCR: | | \ | WORK ORDE | R NON-CONFOR | MANCE (NCR) |) | | |
| DATE | STEP | Description of NC | Corrective Act | | Section B | Verification | Approval | Approval |
| | SILF | Section A | Initial Chief Eng | Action Descriptio Chief Eng | on Sign & Date | Section C | Chief Eng | QC Inspector |
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NOTE: Date & initial all entries

Monday, 2/27/2006 4:18:24 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: SADDLE, INBOARD, RS, 206 Customer: CU-DAR001 Dart Helicopters Services Part Number: D26662 Job Number: 25981 Job Number: Description: Seq. #: **Machine Or Operation:** SECOND CHECK 5.0 Comment: SECOND CHECK HAND FINISHING RESOURCE #1 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 POWDER COATING POWDER COATING 7.0 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 8.0 Comment: INSPECT POWDER COAT PACKAGING RESOURCÉ #1 9.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 10.0 Comment: DOCUMENT CONTROL 04/02/27 Inspection Level 21 u 06.8621 Job Completion

| Dart Aerospace |
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| W/O: | | WORK ORDER CHANGES | | | | | | | |
|---------|------|--------------------|----------------|-------|--------|-------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PR | OCEDURE CHANGE | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | • | | | | | | |
| Part No | • . | PΔR #• | Fault Category | NC NC | R· Yes | No DO | ۸٠ | Date: | |

QA: N/C Closed: ____ Date: ____

| NCR: WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | | | | | | | | |
|---------------------------------------|------|--|----------------------|-----------------------------|---------------------|-----------|--|---------|---|--|--|--|------------------------|-----------------------|--------------------------|
| | | Description of NC | | Corrective Action | | Section B | | Annaval | A | | | | | | |
| DATE | STEP | Section A | Initial Chief Eng | Action Descrip Chief Eng | tion Sign & Date | | | | | | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | | , | · | 6 | | | | | | | | | |
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NOTE: Date & initial all entries

| DART AEROSPACE LTD | Work Order: | 25981 |
|--|--------------|-------------|
| Description: 206 Saddle, Inboard, Right side | Part Number: | D2666-2 |
| Inspection Dwg: D2666 Rev. B | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

| · | | | | Red | corded Actu | ıal Dimensi | ons | | |
|-----|----------|----------|-------------------|---------------------------------------|-------------|-------------|---------|----------|--|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | Ву | Date |
| A | 0.100 | 0.140 | | 124 | 124 | 121 | .122 | | |
| В | 0.100 | 0.140 | | 126 | 1123 | 122 | -121 | | |
| С | 0.100 | 0.140 | | 119 | 123 | .12/ | 119 | | |
| D | 0.210 | 0.230 | | 220 | 218 | .220 | 220 | | |
| E | 1.245 | 1.255 | | 1.250 | 4.256 | 4250 | 1,250 | | |
| F | 1.245 | 1.255 | | 1.250 | 6230 | 1,238 | 1.249 | | |
| G | 5.990 | 6.010 | | 6001 | 6.001 | 6001 | 6.003 | | |
| Н | 0.510 | 0.515 | | .514 | -514 | .514 | .514 | | |
| | 1.674 | 1.684 | | 1.679 | 1679 | 1.679 | 1,679 | | |
| J | 2.495 | 2.505 | | 2,500 | 2.500 | 2.500 | 2,500 | | |
| ·K | 0.257 | 0.262 | DT8683 | | | | | | |
| , L | 0.312 | 0.317 | DT8686 | | | | | | |
| М | 0.235 | 0.240 | | .238 | ,238 | .238 | · X J [| dig. | |
| N | 0.100 | 0.140 | | 121 | 119 | 119 | 120 |) | |
| 0 | 0.540 | 0.560 | | . 448 | .548 | 53/8 | .549 | | |
| Р | 0.490 | 0.510 | | .499 | , 446 | .487 | 498 | | |
| ,Q | 3.609 | 3.619 | | 3.613 | 3,613 | 3613 | 3.613 | | ······································ |
| R | 2.470 | 2.510 | | 2.418 | 2/4/8 | 2.498 | 2,498 | | |
| S | 0.240 | 0.270 | - | 25/ | 125 | 25 | 251 | | |
| T | 0.100 | ~0.180 | | 145 | 145 | 145 | 145 | | |
| U | 0.313 | 0.318 | DT8686 | | | | | | |
| V | 1.125 | 1.145 | | 1-132 | 1/3/ | 1,13/5 | 1.1315 | | |
| W | 1.565 | 1.585 | DT8695 A/B | | | | - | | |
| X | | | | | | | | | |
| Y | | | | | | | | | |
| Z | | | | | | No. | | <i>i</i> | |
| AA | | | | \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ | | | | · | |
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| AF | mq. * | | | | | | | | |
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| | Acc | ept/Reje | ct | | x | | | | |

| <i>*</i> | <i> </i> | <u></u> | • |
|---------------------------------|----------|------------|----------|
| Measured by: \(\sum_{\lambda}\) | 151 | Audited by | me |
| Date: 06,06,14 | 06/06/15 | Date: | 06/06/15 |
| Date: 06,06,14 | 06/06/15 | Date: | 0606/15 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|----------|
| Α | | New Issue | RF | |
| В | 99.04.19 | Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A | RF | |
| С | 99.11.10 | Added Dim. R-T | RF | |
| D | 02.12.12 | Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B | KJ/RF | |

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| DART AEROSPACE LTD | Work Order: | 25981 |
|--|--------------|-------------|
| Description: 206 Saddle, Inboard, Right side | Part Number: | D2666-2 |
| Inspection Dwg: D2666 Rev. B | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

| Dim Min Max Go/No Go Gauge 1 2 3 4 By | | | | | Re | corded Act | ual Dimens | ions | | |
|--|-----|-------|-------|------------|----------|------------|---|-------|----|------|
| B | Dim | Min | Max | | 1 | 2 | 3 | . 4 | Ву | Date |
| C 0.100 0.140 | Α | 0.100 | 0.140 | | 1/23 | - /22 | -122 | -/2\ | | |
| C 0.100 0.140 | В | 0.100 | 0.140 | | .123 | | -/22 | 1./ai | | |
| D 0.210 0.230 | С | 0.100 | | | 1/21 | -/20 | 1./23 | 1.124 | | |
| E 1.245 1.255 | D | 0.210 | 0.230 | | .218 | .218 | -219 | 1.218 | | |
| G 5.990 6.010 6.003 6.003 6.003 6.003 6.003 1.0510 1.0510 0.515 1.514 5.14 5.14 5.14 1.684 1.674 1.684 1.674 1.684 1.674 1.684 1.679 | Е | 1.245 | 1.255 | | | 1.250 | 1.250 | 1-249 | | |
| G 5.990 6.010 6.003 6.003 6.003 6.003 6.003 1.010 0.515 1.514 5.14 5.14 5.14 5.14 1.684 1.674 1.684 1.674 1.684 1.674 1.684 1.674 1.684 1.674 1.684 1.674 1.684 1.674 1.684 1.674 1.679 1.750 2.505 2.505 2.500 2. | F | | 1.255 | | | | 1.25 | 1-250 | | |
| H 0.510 0.515 | G | 5.990 | 6.010 | | 6.002 | 6.003 | 6-002 | 6-002 | | |
| 1 | Н | 0.510 | 0.515 | | 1.514 | 1.514 | -514 | .514 | | |
| J 2.495 2.505 | ī | 1.674 | 1.684 | | 1.679 | 1.678 | 1.679 | 1-679 | | |
| K 0.257 0.262 DT8683 | J | | | | 2.500 | 2.501 | 2.500 | 2-500 | | |
| M 0.235 0.240 | K | 0.257 | 0.262 | DT8683 | <i>2</i> | | / | | | |
| O 0.540 0.560 | L | 0.312 | 0.317 | DT8686 | | | | | | |
| O 0.540 0.560 P 0.490 0.510 Q 3.609 3.619 R 2.470 2.510 S 0.240 0.270 T 0.100 0.180 U 0.313 0.318 DT8686 V 1.125 1.145 W 1.565 1.585 DT8695 A/B X Y Z AA AB AC AB AC AG | М | 0.235 | 0.240 | | -239 | -239 | -238 | 239 | | |
| O 0.540 0.560 P 0.490 0.510 Q 3.609 3.619 R 2.470 2.510 S 0.240 0.270 T 0.100 0.180 U 0.313 0.318 DT8686 V 1.125 1.145 W 1.565 1.585 DT8695 A/B X Y Z AA AB AC AB AC AG | N | | | | .120 | | - 119 | .//9 | | |
| Q 3.609 3.619 3.614 3.6/3 3.6/4 3.6/8 R 2.470 2.510 2.500 2.500 2.500 2.500 S 0.240 0.270 .252 .253 .255 .256 T 0.100 0.180 JHS ./4S ./4S ./4S ./4S ./4S ./4S ./4S ./4 | 0 | 0.540 | | | -550 | .550 | | -550 | | |
| Q 3.609 3.619 3.614 3.6/3 3.6/4 3.6/8 R 2.470 2.510 2.500 2.500 2.500 2.500 S 0.240 0.270 .252 .253 .255 .256 T 0.100 0.180 JHS .145 .145 .145 .145 .145 .145 .145 .145 | Р | 0.490 | 0.510 | , | .498 | .500 | .499 | 499 | | |
| R 2.470 2.510 | Q | 3.609 | 3.619 | | 3.614 | 3.6/3 | 3614 | 3-614 | | |
| T 0.100 0.180 | R | 2.470 | 2.510 | | 2.500 | 2.500 | 2.500 | 2500 | | |
| U 0.313 0.318 DT8686 V 1.125 1.145 W 1.565 1.585 DT8695 A/B X Y Z AA AB AC AD AE AF AG | S | 0.240 | 0.270 | | 252 | .253 | .255 | -256 | | |
| V 1.125 1.145 //3/ //3/ //3/ W 1.565 1.585 DT8695 A/B //3/ //3/ X , , , , Y , , , , Z , , , , AA , , , , AB , , , , AC , , , , AB , , , , AC , , , , AB , , , , , AB , , , , , AB , , , , , AB | T | | | | 145 | .145 | .145 | 145 | | |
| W 1.565 1.585 DT8695 A/B | | | | DT8686 | | | | | | |
| X | | | 1.145 | | 1.131 | 1.131 | 1./32 | 1.130 | | |
| Y Z AA A A A A A A A A A A A A A A A A A | | 1.565 | 1.585 | DT8695 A/B | | | | | | |
| Z | | | | | | | , | | | |
| AA | | | | | | | · | | | |
| AB | Z | | | | | | | | | |
| AC | | | | | | | | e. v | | |
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| AE AF AG | | | | | | | | | | |
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| ΔΗ . | | | | | | | | | | |
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| Measured by: | J.L . | Audited by | 92 |
|--------------|----------|------------|----------|
| Date: | 06/06/15 | Date: | 06/06/15 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|----------|
| Α | | New Issue | RF | |
| В | 99.04.19 | Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A | RF | |
| С | 99.11.10 | Added Dim. R-T | RF | |
| D | 02.12.12 | Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B | KJ/RF | |

| DART AEROSPACE LTD | Work Order: | 25981 |
|--|--------------|-------------|
| Description: 206 Saddle, Inboard, Right side | Part Number: | D2666-2 |
| Inspection Dwg: D2666 Rev. B | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|--------|-------|-----------------|-------------------|----------------------------|-------|--------------|----------|----|--|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | Ву | Date |
| Α | 0.100 | 0.140 | | ./21 | -122 | -/21 | .123 | | |
| В | 0.100 | 0.140 | | -120, | .122 | -120 | .122 | | |
| С | 0.100 | 0.140 | | .124 | 121_ | 123 | 123_ | | |
| D | 0.210 | 0.230 | | -215 | -215 | 1.217 | 125 | | |
| E | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1,250 | | |
| F | 1.245 | 1.255 | - | 1.250 | 1.250 | 1.250 | 1.249 | | |
| G | 5.990 | 6.010 | | 6-003 | 6003 | 6-002 | 6002 | | |
| Н | 0.510 | 0.515 | | <14 | 1514 | -514 | 514 | | |
| 1 | 1.674 | 1.684 | | 1.679 | 1.679 | 1.678 | 1.679 | | |
| J | 2.495 | 2.505 | | 2.501 | 2.501 | 2.501 | 2,500 | | |
| K | 0.257 | 0.262 | DT8683 | 7/ | | | | | |
| L | 0.312 | 0.317 | DT8686 | | | | | | |
| М | 0.235 | 0.240 | | 238 | -237 | - 239 | .239 | | |
| N | 0.100 | 0.140 | | . 114 | .1/3 | -113 | .1)4 | | |
| 0 | 0.540 | 0.560 | | -549 | .550 | .547 | .548 | | |
| P | 0.490 | 0.510 | | - H98 | 499 | -49 9 | .500. | | |
| Q | 3.609 | 3.619 | | 3.6/5 | 3.6/4 | 3.6/4 | 3.6/4 | | |
| R | 2.470 | 2.510 | | 2.500 | 2.500 | 2.500 | 2.500 | | , |
| S | 0.240 | 0.270 | | -254 | .254 | 250 | -251 | | |
| T | 0.100 | 0.180 | ., | .145 | 145 | 145 | -145 | | |
| Ū | 0.313 | 0.318 | DT8686 | -1/3 | | | | | |
| V | 1.125 | 1.145 | | 1.129 | 1.131 | 1./3/ | 1.130 | | |
| W | 1.565 | 1.585 | DT8695 A/B | 7 | 17 | | | | |
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| Measured by: | Audited by | me |
|----------------|------------|----------|
| Date: 06/06/15 | Date: | 06/06/15 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|----------|
| Α | | New Issue | RF | |
| В | 99.04.19 | Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A | RF | |
| С | 99.11.10 | Added Dim. R-T | RF | |
| D | 02.12.12 | Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B | KJ/RF | |





| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. | | | |
|----------|-----------|--------------------------|------------------------|--|--|
| CHECKED | APPROVED. | DRAWING NO. D2666 | REV. B SHEET 1 OF 1 | | |
| DATE | | MLE | SCALE | | |
| 97.07.11 | | SADDLE FWD INSIDE HIGH | 2:5 | | |
| A | 97.03.25 | NEW ISSUE | | | |
| | | | | | |

EFFECTIVE DEOs B 97.07.11 | ANGLE AND NOTES ADDED 9095 9122 111/06 DS 98112114 9102 R1.245 98/05/04 DS 0.050 x 45" CHAMFER (TYP) R1.135 0.063 0.110 0.250 SECTION A-A R0.50 0.625 1.808 0.550 1.679 R1.575 1.362 R0.375 (TYP) R1.685 2.500 0.797 r 0.438 1.000 **ENGRAVE PART** ¢0.257 0 NUMBER AND BATCH NUMBER 120 TO MAX DEPTH ¢0.313 0.922 0.500 0.110 OF 0.010 WITH RO.50 0.225 MIN RADIUS R0.250 OF 0.010 1.615 R0.525 0.050 x 45" CHAMFER ALL AROUND BELEASE 0.500 -1.250 1.250 2.500 ECN 008 6.000 # CPODISAS MATERIAL: 7075 T651 OR 7075-T7351 (QQ-A-250/12) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIME, PAINT (EXCEPT BORES) PER DART QSI 005 4.2

NOTE: D2666-1 SHOWN (D2666-2 IS OPPOSITE)
BREAK ALL SHARP EDGES 0.010 TO 0.020

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE DARK TO

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 2598